



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

648.4704

Job Sheet 180405



004970

Part No: 648.4704

Job Qty: 1 ea

Part Name: C45 Overhaul



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/5/18

Job Tracking No:

Due Date: 8/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG OM & OOPM-C45 Rev 4 (648.4704) IPP Rev A 18.04.27 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	8/7/18	8/7/18	0.00	0.00	Start Up Small Fab-3		7/18
100	Small Fab	1 pcs	8/7/18	8/7/18	0.00	1.00	Small Fab-3		7/18 DAS 38
120	QC	1 pcs	8/7/18	8/7/18	0.00	0.00	QC4		7/18 9-89
121	DC	1 pcs	8/7/18	8/7/18	0.00	0.00	DC		7/18 DAS
130	Packaging	1 pcs	8/7/18	8/7/18	0.00	0.00	Packaging3-1		7/18
140	QC21-FG	1 Ea	8/7/18	8/7/18	0.00	0.00	QC21		21 9-89 AUG 27 2018

Part Op 100 - Pick bag and tag

Descriptions: 121 - Supply owner's & overhaul procedures manual

H.A sold

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
NAS1149F0463P	Washer	3 Ea (3 ea)	90-Start up Operation	5078780
NAS1149F0563P	Washer	8 Ea (8 ea)	90-Start up Operation	5067901
188-FPSS-1/4-20-3/8	see P/N 188-FPSS-1/4-20-3/8	2 Ea (2 ea)	100-Small Fab	5075269
188-FSCS-1032-5/8	Screw	4 Ea (4 ea)	100-Small Fab	5078378
600.1309-A	Label	1 Ea (1 ea)	100-Small Fab	
600.1312	Caution Sticker	1 Ea (1 ea)	100-Small Fab	5072105
AN4-23A	Bolt	2 Ea (2 ea)	100-Small Fab	FP23434-40
AN5-21A	Bolt	4 Ea (4 ea)	100-Small Fab	5093603
C2-14-2	Label Rivets	2 Ea (2 ea)	100-Small Fab	5040661
C45-10-1	Spring Pin	1 Ea (1 ea)	100-Small Fab	5040658
C45-10-2	Lock Spring	1 Ea (1 ea)	100-Small Fab	5099970
C45-11-2	Locating Pin	2 Ea (2 ea)	100-Small Fab	5054326
C45-12-1	Lock Bushing	2 Ea (2 ea)	100-Small Fab	5091795
C45-12-6	Retaining Ring	2 Ea (2 ea)	100-Small Fab	5054986
C45-13-1	Keeper Bushing	2 Ea (2 ea)	100-Small Fab	
C45-13-2	Spacer	2 Ea (2 ea)	100-Small Fab	5097746
C45-13-5	Keeper Spring	1 Ea (1 ea)	100-Small Fab	5029308
C45-3-1	Radial Bearing	2 Ea (2 ea)	100-Small Fab	5091767
C45-3-12	DU Bearing	1 Ea (1 ea)	100-Small Fab	5091768
C45-3-2-1	Snap Ring	2 Ea (2 ea)	100-Small Fab	5097898
C45-3-4-1	Retaining Ring	4 Ea (4 ea)	100-Small Fab	5068056
C45-3-5	Spacer	2 Ea (2 ea)	100-Small Fab	5097745
C45-3-8A	Actuator Shaft Bushing	1 Ea (1 ea)	100-Small Fab	5076197

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																	
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																																																																															
Description Work Order Deviation																																																																																			
DART AEROSPACE Container No: S101682 Part: 548 1704 Job No: 160405 Serial No./Batch: S101682 Hevis: 1.4 Inspector: Exp Date: Instructions: Date: 08/13/18																																																																																			
Completed By																																																																																			
Lead hand / Supervisor Approval Verification																																																																																			
QC / QA Coordinator Approval																																																																																			
<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <th colspan="3" style="text-align: left;">Root Cause:</th> <th colspan="3"></th> </tr> <tr> <td style="width:30%;">Environment</td> <td style="width:10%;">☐</td> <td style="width:10%;">No</td> <td style="width:30%;"></td> <td style="width:10%;"></td> <td style="width:10%;"></td> </tr> <tr> <td>Design</td> <td>☐</td> <td>Open</td> <td></td> <td></td> <td></td> </tr> <tr> <td>Doc/Data</td> <td>☐</td> <td>Offs</td> <td></td> <td></td> <td></td> </tr> <tr> <td>Equip/Tooling</td> <td>☐</td> <td>Supp</td> <td></td> <td></td> <td></td> </tr> <tr> <td>Handling/Pre</td> <td>☐</td> <td>Train</td> <td></td> <td></td> <td></td> </tr> <tr> <td>Material</td> <td>☐</td> <td>Use f</td> <td></td> <td></td> <td></td> </tr> <tr> <td>Internal Transport</td> <td>☐</td> <td>Poor</td> <td>☐ Crushing</td> <td>☐ Countersink</td> <td>☐ Loss/Surge Program</td> </tr> <tr> <td>Tribal Knowledge</td> <td>☐</td> <td>Rushing</td> <td>☐ Heat Treat</td> <td>☐ Cut Too Short</td> <td>☐ Off-set</td> </tr> <tr> <td>LOA</td> <td>☐</td> <td>Product Improvement</td> <td>☐ Wave/Twist in Tube</td> <td>☐ Instructions Incomplete/Unclear</td> <td>☐ Mislabeled</td> </tr> <tr> <td>Substation</td> <td>☐</td> <td>Process Improvement</td> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Fit/Function</td> </tr> <tr> <td>Past Expiry Date</td> <td>☐</td> <td>Manufacturing Process</td> <td></td> <td></td> <td>☐ Misaligned/off center</td> </tr> <tr> <td>Misidentified</td> <td>☐</td> <td>Past Due</td> <td colspan="3">OTHER :</td> </tr> </table>						Root Cause:						Environment	☐	No				Design	☐	Open				Doc/Data	☐	Offs				Equip/Tooling	☐	Supp				Handling/Pre	☐	Train				Material	☐	Use f				Internal Transport	☐	Poor	☐ Crushing	☐ Countersink	☐ Loss/Surge Program	Tribal Knowledge	☐	Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Off-set	LOA	☐	Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Mislabeled	Substation	☐	Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Fit/Function	Past Expiry Date	☐	Manufacturing Process			☐ Misaligned/off center	Misidentified	☐	Past Due	OTHER :		
Root Cause:																																																																																			
Environment	☐	No																																																																																	
Design	☐	Open																																																																																	
Doc/Data	☐	Offs																																																																																	
Equip/Tooling	☐	Supp																																																																																	
Handling/Pre	☐	Train																																																																																	
Material	☐	Use f																																																																																	
Internal Transport	☐	Poor	☐ Crushing	☐ Countersink	☐ Loss/Surge Program																																																																														
Tribal Knowledge	☐	Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Off-set																																																																														
LOA	☐	Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Mislabeled																																																																														
Substation	☐	Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Fit/Function																																																																														
Past Expiry Date	☐	Manufacturing Process			☐ Misaligned/off center																																																																														
Misidentified	☐	Past Due	OTHER :																																																																																

C45-3-8B	Actuator Shaft Bushing ✓	1 Ea (1 ea)	100-Small Fab
C45-3-9	Lever Spring ✓	1 pcs (1 ea)	100-Small Fab
C45-4-1	Trunnion Bushing ✓	2 Ea (2 ea)	100-Small Fab
C45-5-1	Lever Stop Pin ✓	1 Ea (1 ea)	100-Small Fab
C45-7-1P	LOADBEAM BUMPER ✓	1 Ea (1 ea)	100-Small Fab
C45-7-2	Lock Bumper ✓	2 Ea (2 ea)	100-Small Fab
C45-8-4	Solenoid Cover Gasket ✓	1 Ea (1 ea)	100-Small Fab
MS21044N5	Nut ✓	4 Ea (4 ea)	100-Small Fab
MS27039-4-08	Screw ✓	1 Ea (1 ea)	100-Small Fab

5072801

5089520

5075547

5040657

5029332

5095587

5094831

5097089

5097087

5078803

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	NAS1149F0463P	3	747	0
	NAS1149F0563P	8	626	0
100-Small Fab	188-FPSS-1/4 20-3/8	2	0	0
	188-FSCS-1032-5/8	4	377	0
	600.1309-A	1	0	0
	600.1312	1	22	0
	AN4-23A	2	588	0
	AN5-21A	4	73	0
	C2-14-2	2	206	0
	C45-10-1	1	91	0
	C45-10-2	1	11	0
	C45-11-2	2	78	0
	C45-12-1	2	16	0
	C45-12-6	2	84	0
	C45-13-1	2	13	0
	C45-13-2	2	82	0
	C45-13-5	1	95	0
	C45-3-1	2	18	0
	C45-3-12	1	12	0
	C45-3-2-1	2	54	0
	C45-3-4-1	4	156	0
	C45-3-5	2	78	0
	C45-3-8A	1	57	0
	C45-3-8B	1	38	0
	C45-3-9	1	0	0
	C45-4-1	2	48	0
	C45-5-1	1	41	0
	C45-7-1	1	0	0
	C45-7-2	2	12	0
	C45-8-4	1	0	0
	MS21044N5	4	139	0
	MS27039-4-08	1	78	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐				